

Work Order ID 75219

75219

Page 1

October-19-11 11:07:38 AM

Item ID: D3393-041 *Ali* Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Battery Lock Assembly *3*
 Start Date: 19/10/2011 Start Qty: ~~4.00~~ ***4*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: *M.L.J* Date: *11/10/19* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3393	Rev A								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest. 2-Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-53-Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten								
110	Large Fab	0.00							
110									
Large Fab	Memo	0.00							
Large Fab	Tack Weld lock shaft to flat cam of a Max 1/8" Long QtyPart Number Description Batch A/RN/A SS Rod <i>M117509</i>								
120	QC9- Inspet visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

3 FF 12-02-15

EL 12-2-17 (X3)

CP 12-02-21 (X3) /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					<u>8</u>			
Small Fab	Memo	0.00				<u>9</u>	<u>FF</u>	<u>12-02-22</u>	
Small Fab	Apply Crazy Glue to cap and press into Body	9567K21							
	Batch: <u>7120590</u>								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: <u>493</u>								
Packaging	Memo	0.00							
Packaging									

12-02-23 (3)

12/2/27 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/2/27

12-02-27
(3)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

October-19-11 11:07:43 AM

Page 1

Work Order ID: 75219

75219

Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

5/16WC		Purchased	No			100	Each	1,554.000	2	8			
5/16WC									**	(6)	FF	12-02-15	
SS Flat Washer 5/16 FW516S1													

Location	Loc Qty	Loc Code
st376	1161	
117332	1161	
ST377	393	
115072	79	
115174	53	
116643	261	

9567K21		Purchased	No			100	Each	27.0000	2	8			
9567K21									**	(6)	FF	12-02-15	
Polyethelene Cap													

Location	Loc Qty	Loc Code
ST380	27	
110822	27	

D2728-7		Manufactured	No			100	Each	0.0000	0	0			
D2728-7									**	(3)	FF	12-02-15	
Dart Logo label													

D3373-1		Manufactured	No			100	Each	25.0000	1	4			
D3373-1	KA								**	(3)	FF	12-02-15	
Cam Lock													

Location	Loc Qty	Loc Code
ST049	25	
58463	5	
74862	20	

75666

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Parent Item: D3393-041

D3393-041

Parent Item Name: Battery Lock Assembly

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

D3393-1 Manufactured No

100 Each 3.0000 1 4

D3393-1

Battery Lock Casing

**

3 FF 12-02-15

Location

Loc Qty

Loc Code

ST487

3

62953

3

D3393-3 Manufactured No

140 Each 0.0000 1 4

D3393-3

Cam Lock Shaft

**

77090A

3 FF 12-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

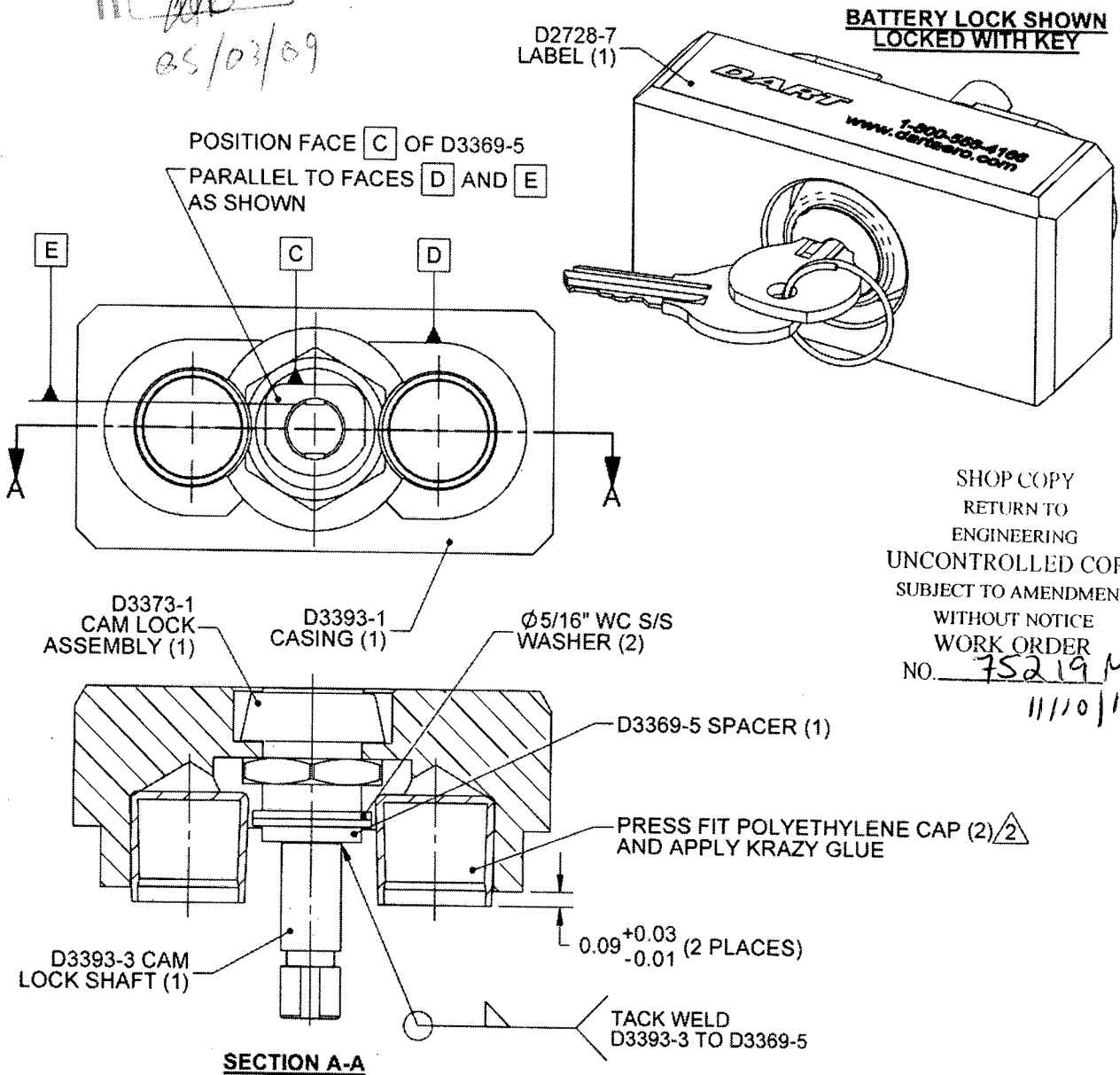
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED AKS	DRAWING NO. D3393	REV. A SHEET 1 OF 3
DATE 05.02.08		TITLE BATTERY LOCK	SCALE 1:1
A	05.02.08	NEW ISSUE	

RELEASED
05/03/09



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75219 M.L.U
11/10/19

D3393-041 BATTERY LOCK ASSEMBLY

NOTES:

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

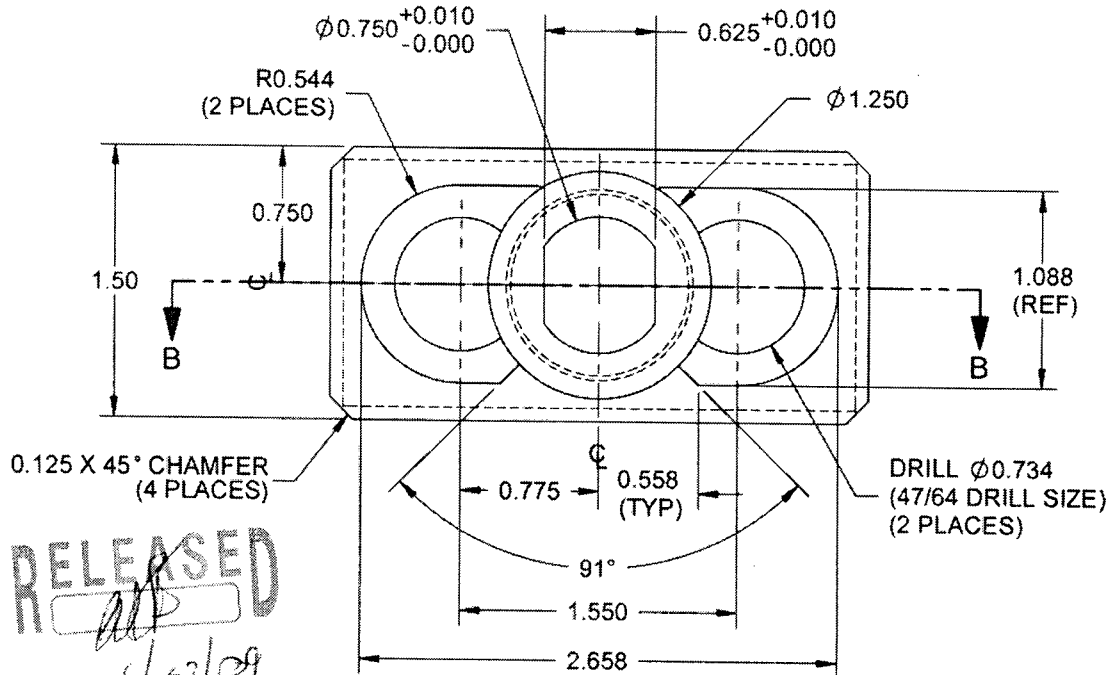
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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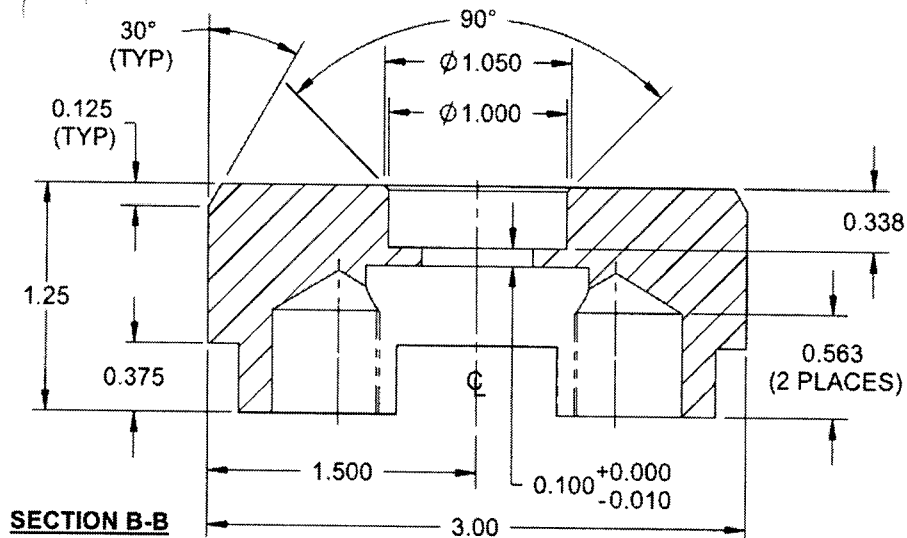
NOTE: Date & initial all entries



DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A SHEET 2 OF 3
DATE 05.02.09	TITLE BATTERY LOCK		SCALE 1:1



RELEASED
05/03/09



D3393-1 CASING

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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75219

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

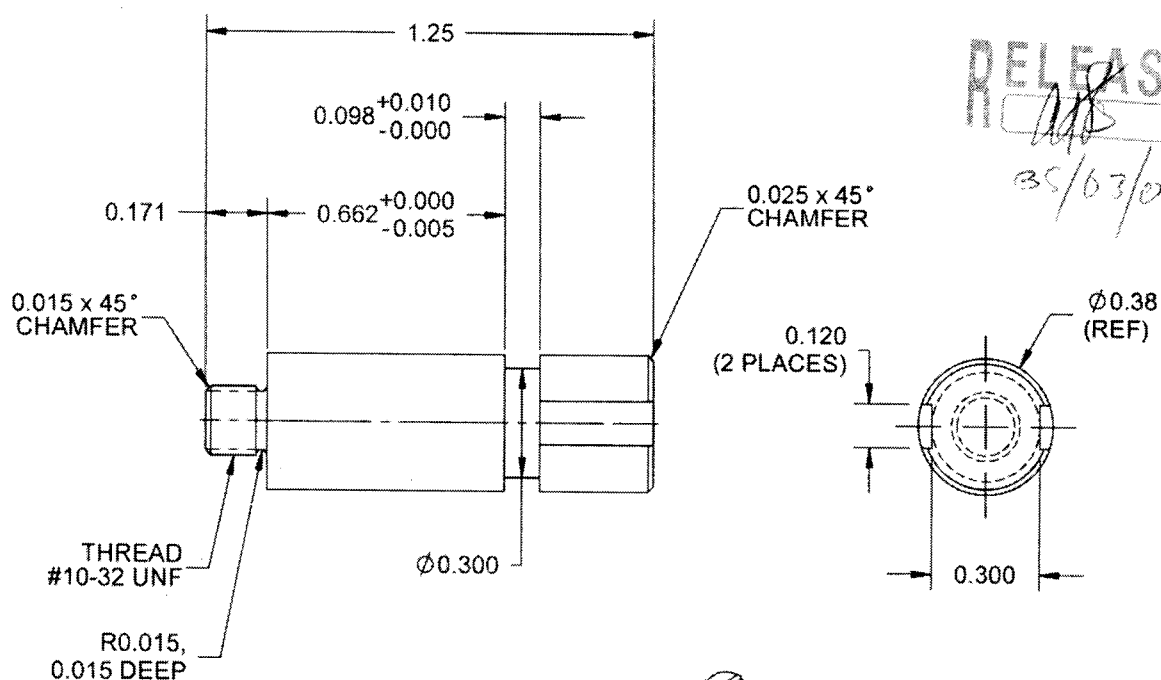
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3393	REV. A
DATE 05.02.09		TITLE BATTERY LOCK	SHEET 3 OF 3
			SCALE 2:1



D3393-3 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

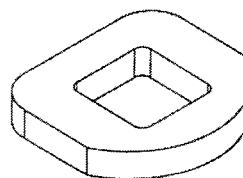
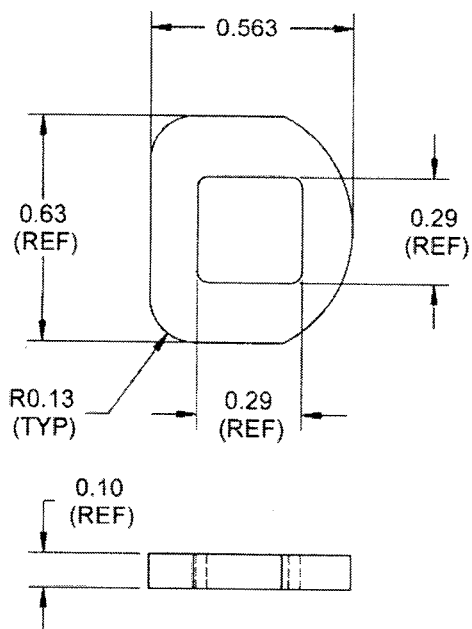
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A
DATE 04.12.16		TITLE BATTERY LOCK	SHEET 4 OF 4 SCALE 2:1

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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